



Dart Aerospace Ltd.
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D2745

Job Sheet 187157



Part No: D2745

Job Qty: 100 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/18

Job Tracking No:

Due Date: 12/21/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV B IPP C 02.03.07 Update to turn in house NG IPP Rev:D 07-10-23 Removed tumbling JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea		12/21/18	0.00	0.00	Start Up Machining-1		JSD 12/12/18
100	Hardinge	100 pcs		12/21/18	0.01	7.33	Hardinge		" "
120	QC	100 pcs		12/21/18	0.00	0.00	QC8		2006 E/12/15
130	Packaging	100 pcs		12/21/18	0.00	0.00	Packaging3-1 FP001		DEC 18-12-18 (100)
140	QC21-SA	100 Ea		12/21/18	0.00	0.00	QC21		21 DEC 19 2018

Part Op 100 - 1-Turn as per Dwg D2515
Descriptions: 130 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	9.5900 ft (.0959 ea)	90-Start up Operation	5119664 5115940

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R0.750	10	107	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____ _____ _____					

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.060inches $\pm$ 0.010	0.070 0.050		
2	Bushing	0.400inches $\pm$ 0.010	0.410 0.390		
3	Bushing	0.060inches $\pm$ 0.010	0.070 0.050		
4	Bushing	1.020inches $\pm$ 0.010	1.030 1.010		
5	Bushing	0.030inches $\pm$ 0.010	0.040 0.020		
6	Bushing	20.000Degrees $\pm$ 0.000	20.000 20.000		
7	Bushing	0.472inches $\pm$ 0.010	0.482 0.462		
8	Bushing	0.375inches + 0.006 - 0.001	0.381 0.374		
9	Bushing	0.560inches $\pm$ 0.010	0.570 0.550		
10	Bushing	0.750inches $\pm$ 0.010	0.760 0.740		

Plex 11/28/18 11:01 AM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION

DEPARTMENT/PROCESS

Part: D2745
Job No: 187157
Serial No/Batch: S137492
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 12/12/18

Container No: S137492



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Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

ed :

Disposition

MRB (QSI042)

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

☐ Pressure/Forced
☐ Bending
☐ Crushing
☐ Cracks
☐ Crimp/Kink/Ripple/Wave/Twist
☐ Marks/Chatter
☐ Mislabeled

☐ Contamination
☐ Misaligned/off center
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Incomplete/Unclear Instructions
☐ Drill Holes
☐ Fit/Function

FAULT CATEGORY

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain Direction
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set/Set-up

☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☐ Part Lost/Missing
☐ Misread

Other/Details: